

5/35

DART AEROSPACE LTD		Work Order:	23972
Description: Basket Lid Assembly		Part Number:	D2989-041
			D2989-043
Drawing: D2989 Rev A23		Qty:	1
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Open Traveler Dwg not required	KJ	05.08.08	1																				
2	WS	Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing. Batch: <u>M17213</u> Cut Qty. 4 D2236-1 from: Qty. 1 D3166-3 Batch: <u>B23312</u> Note: D3166-3 included in D2989-041 Bom	WA	05/08/12	1																				
3	WS	Drill holes in tubing as D2989-041 per Dwg D2989	WA	05/08/12	1																				
4	WS	Deburr <i>REMOVE ALL MARKINGS ON MATERIAL</i>	WA	05/08/12	1																				
5	WS	Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required Pick: Only apply for D2989-041 BOM. <table><tr><th>Qty</th><th>Part number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2581</td><td>Mounting Brackets</td><td><u>B23310</u></td></tr><tr><td>2</td><td>D2327-3</td><td>Bushing</td><td><u>B23447</u></td></tr><tr><td>1</td><td>D2506</td><td>Label Plate</td><td><u>B23851</u></td></tr><tr><td>15sf</td><td>M304EX0.75-16F</td><td>Expanded Metal</td><td><u>M18074</u></td></tr></table> Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.	Qty	Part number	Description	Batch	2	D2581	Mounting Brackets	<u>B23310</u>	2	D2327-3	Bushing	<u>B23447</u>	1	D2506	Label Plate	<u>B23851</u>	15sf	M304EX0.75-16F	Expanded Metal	<u>M18074</u>	WA	05/08/15	1
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15sf	M304EX0.75-16F	Expanded Metal	<u>M18074</u>																						
6	WS	Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041	WA	05/08/15	1																				
7	WS	Drill holes in tubing as D2989-043 per drawing D2989	WA	05/08/15	1																				
8	WS	Deburr <i>REMOVE ALL MARKINGS ON MATERIAL</i>	WA	05/08/15	1																				
9	WS	Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required. Pick: Only apply for D2989-043 BOM. <table><tr><th>Qty</th><th>Part number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3182-1</td><td>Hinge</td><td><u>B23085</u></td></tr><tr><td>8 sf</td><td>M304EX0.75-16F</td><td>Expanded Metal</td><td><u>M18074</u></td></tr></table> Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid. Identify as D2989-043	Qty	Part number	Description	Batch	2	D3182-1	Hinge	<u>B23085</u>	8 sf	M304EX0.75-16F	Expanded Metal	<u>M18074</u>	WA	05/08/16	1								
Qty	Part number	Description	Batch																						
2	D3182-1	Hinge	<u>B23085</u>																						
8 sf	M304EX0.75-16F	Expanded Metal	<u>M18074</u>																						
10	QC9 & 6	Inspect D2989-041/-043 Weld and Dimensions	J	05-08-16	1																				
11	FP	Powder Coat White (Ref. 4.3.5.2) D2989-041/-043 as per QSI 005 4.3 & Dwg D2989	MM	05 08 17	1																				
12	FP	Wing walk D2989-041 only as per Dwg D2989 and QSI 005 4.4 Spray Paint Black: <u>M17746</u> Wing Walk: <u>M17829</u>	MM	05 08 18	1																				
13	QC3	Inspect Powder Coat and Wing Walk	U	05 08 18	1																				
14	FP	To GA Cell for Assembly	SAD	06/08/18	1																				

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	01.11.29	Revised Pick List (NCR 589)	SM	
C	02.05.11	Clarify step 5	NG	
D	02.07.24	Re-format; Modify Step 2	KJ	
E	02.08.15	D3166-3 was D3166-1	KJ	
F	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ	
G	03.01.31	Incorporated D2989-043	KJ/RF	

RELEASED